

# Work Order ID 62209

Wednesday, September 22, 2010 11:45:10 A

Page 1

Item ID: D3537-1

Accept

Revision ID:

Item Name: Wearpad

Setup Start

Stop

Start Date: 9/22/2010 Start Qty: 40.00

Required Date: 9/29/2010 Req'd Qty: 40.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3537

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3537 ☒ Dwg Rev: C ☐ Prog Rev: C ☐ 2-Deburr if necessary

304 .063

1B 10-9-28

(44)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

1B 10-9-28

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

S. 10/09/29

counts  
(744)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

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Required Date: 9/29/2010 Req'd Qty: 40.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. 2-Identify as D3537-1

0.00

0.00

SB 10/09/29

44

140



Large Fab

Large Fab

Large Fab

Memo

Qty Description Batch A/R 2059B Hardcoat  
1115450 1-Weld as per Dwg D3537 using Jig DT 8210 2-Remove any weld that penetrated through Wearpad if necessary

0.00

0.00

10-10-20 X44

150



QC

Quality Control

QC10- Inspect visual per QS1004- ground welds

Memo

0.00

0.00

44 10/10/20

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Work Order ID 62209

Wednesday, September 22, 2010 11:45:10 A



Page 3

Item ID: D3537-1

Accept



Setup Start



Revision ID:

Item Name: Wearpad

Stop



Start Date: 9/22/2010 Start Qty: 40.00



Cust Item ID:

Required Date: 9/29/2010 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				44			<i>Stare</i>
170  Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 <i>M112588</i> Memo START TIME: <i>8:55</i> <input type="checkbox"/> OVEN TEMPERATURE: <i>320</i> <input type="checkbox"/> FINISH TIME: <i>8:25</i>	0.00  0.00		<i>OK 10-10-22</i>		<i>1/4</i>			
180  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00		<i>7/11 10/10/22</i>		44	0		

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

[REDACTED]

Page 4

**Accept**

[illegible]**Setup Start**

**Abstract**

**Stop**

**00000000000000000000000000000000**

**Cust Item ID:**

**Customer:**

\_\_\_\_\_

Run Start

**Abstract**

**Stop**



**Insp.  
Stamp**

Identify as per dwg & Stock Location:

FR 7

0.00

Hours *BR 10-10-22*



### Packaging

## Memo

0.00

## Packaging

QC21- Final Inspection - Work Order Release

0.00

**Abstract**

QC

## Memo

0.00

## Quality Control

10/10/22

MF 10-10-22

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Wednesday, September 22, 2010 11:45:14 AM

Page 1

Work Order ID: 62209

Parent Item: D3537-1

Parent Item Name: Wearpad




Start Date: 9/22/2010

Required Date: 9/29/2010

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 		Purchased	No			100	sf	160.8400	0.106	4.463158	4.7		
304/316 Sheet .063													

1210-9-28

Location

Loc Qty

Loc Code

MAT

146.7

111323

0

115688

146.7

MAT20

14.14

115440

14.14

115688

44

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	62209
<b>Description:</b> Wearpad		<b>Part Number:</b>	D3537-1
<b>Inspection Dwg:</b> D3537 <b>Rev:</b> C		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.250	+/-0.010	4.251	X		V IB07	
3.500	+/-0.010	3.499	X		V	
1.965	+/-0.010	1.971	X		V	
2.795	+/-0.010	2.795	X		V	
3.625	+/-0.010	3.621	X		V	
0.220 x 0.380	+/-0.010	0.22 x 0.380	X		V	

<b>Measured by:</b> IB	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 10-9-28	<b>Date:</b> 10/09/29	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM	
B	07.04.27	Dimensions revised per Dwg Rev. B	KJ/JLM	
C	07.05.28	Dimensions revised per Dwg Rev. C	KJ/JLM	

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

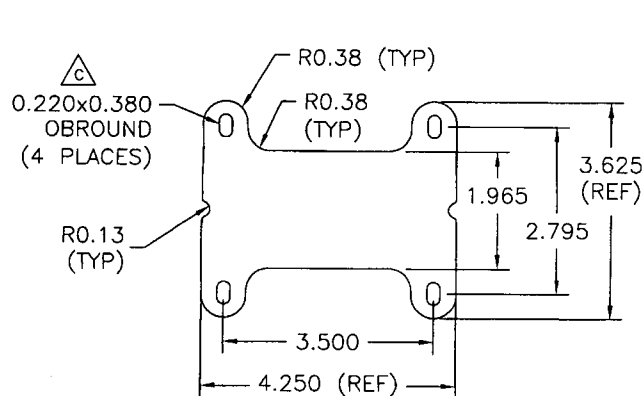
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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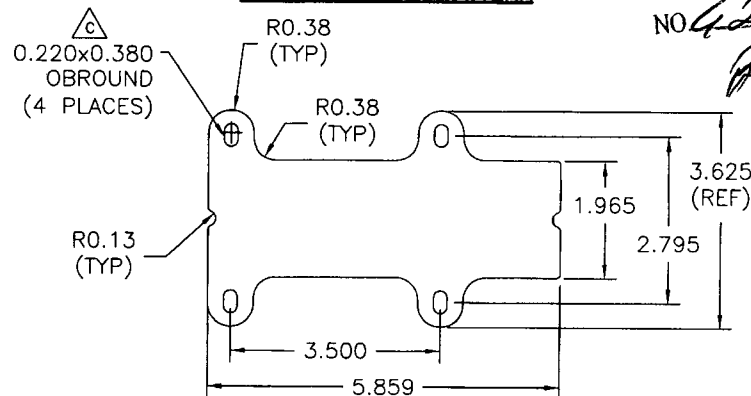
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER  
NO 42209  
RJ10-922

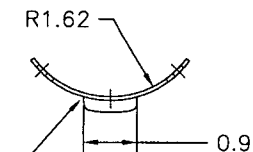
### D3537-1F FLAT PATTERN



### D3537-3F FLAT PATTERN

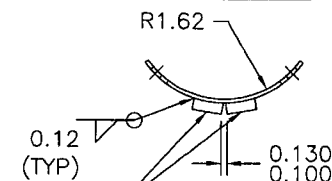


### SECTION A-A



APPLY 2 LAYERS OF  
2059B HARDCOAT WELDS  
TO WITHIN 0.25 OF  
WEARPAD ENDS  
0.188 TO 0.250 THICK

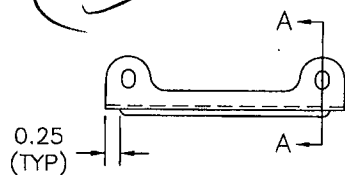
### SECTION B-B



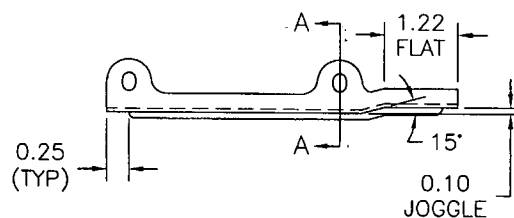
D2941-300  
REMOVE POWDER  
COAT FROM THESE  
SURFACES

**RELEASED**  
07.05.08 AB  
PER ECU  
962

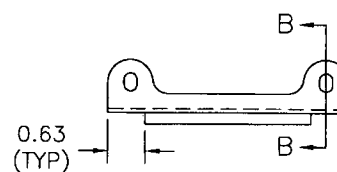
### D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



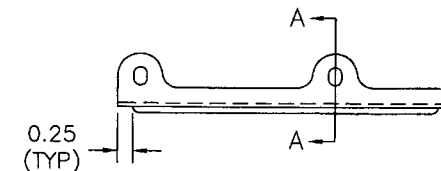
### D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



### D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



### D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



### D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE USA, INC.

DESIGN	C B	DRAWN BY	P H	DART AEROSPACE USA, INC.
CHECKED	A	APPROVED	A	PORT HADLOCK, MA
DATE	07.04.13	DRAWING NO.	D3537	REV. C
		TITLE	WEARPAD	SHEET 1 OF 1
				SCALE 1:2

W/O:		WORK ORDER CHANGES					
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